

Work Order ID 116467

April-16-14 11:34:36 AM

116467

Page 1

Item ID: D2802-1

Accept

N900040100

Setup Start *NS1*

Revision ID:

Stop *NS2*

Item Name: Arm

Start Date: 4/16/14 Start Qty: 4.00

4

Cust Item ID:

Required Date: 5/01/14 Req'd Qty: 4.00

4

Customer:

Reference:

Approvals: Process Plan: MLJ Date: 4/04/16 Tooling: _____ Date: _____

Run Start *NR1*

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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Draw Nbr	Revision Nbr
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D2802	Rev A
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100

0.00

100

BAND SAW

Bandsaw

Memo

0.00

Jeaspa Bandsaw

Cut blanks 17.800" long

4

14-04-21

110

0.00

110

HAAS CNC VERTICAL MACHINING #1

HAAS 1

Memo

0.00

HAAS CNC vertical machine #1

Machine as per folio FA101 Counter sink .375 dia as per dwg

4

Ø

17H 14/04/22

120

0.00

120

QC2- Inspect parts off machine FAI/FAIB

QC

Memo

0.00

Quality Control

4

Ø

17H 14/04/22

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Page 2

Item ID: D2802-1

Accept

N900040100Setup Start ***NS1***

Revision ID:

Stop ***NS2***

Item Name: Arm

Start Date: 4/16/14

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Cust Item ID:

Required Date: 5/01/14

Req'd Qty: 4.00

4

Customer:

Reference:

Approvals:

Process Plan: _____

Date: _____

Tooling: _____

Date: _____

Run Start ***NR1***

QC: _____

Date: _____

SPC (Y/N): _____

Date: _____

Stop ***NR2***Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

130

QC8- Inspect parts - second check

0.00

130

QC

Memo

0.00

Quality Control

DAS
44
9-89

14/04/22

140

Small Fab

0.00

140

Small Fab

Memo

0.00

Small Fab

Deburr NO sharp edges.

DAS
27
9-89

N/A 4/1/22

150

QC5- Inspect part completeness to step on W/O

0.00

150

QC

Memo

0.00

Quality Control

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Page 3

Accept

N900040100

Setup Start *NS1*

Stop *NS2*

Item Name: Arm

Start Date: 4/16/14 **Start Qty:** 4.00 ***4***

Cust Item ID:

Required Date: 5/01/14 **Req'd Qty:** 4.00 ***1***

Customer:

Reference:

Approvals: **Process Plan:** _____ **Date:** _____ **Tooling:** _____ **Date:** _____

Run Start *NR1*

QC: _____ **Date:** _____ **SPC (Y/N):** _____ **Date:** _____

Stop *NR2*

Sequence ID/
Work Center ID

Operation Description

**Set Up/
Run Hours**

Tool ID	Tool #	Plan Code
---------	--------	-----------

Accept Qty	Reject Qty	Reject Number	Insp. Stamp

160

Identify as per dwg & Stock Location: U/A 003 0.00

0.00

160

Packaging

Memo

0.00

Packaging

170

QC21- Final Inspection - Work Order Release

0.00

170

QC

Memo

0.00

Quality Control

4/x 14-4-23 JT

14-4-23

14.04.23

Picklist Print

April-16-14 11:34:39 AM

Page 1

Work Order ID: 116467

116467

Parent Item: D2802-1

D2802-1

Parent Item Name: Arm

Start Date: 4/16/14

Required Date: 5/01/14

Start Qty: 4.00

Required Qty: 4.00

Comments: IPP: B02.03.18Re-format NG
IPP: C06.02.13Removed p/cEC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M6061T6B0.500X06.00 0		Purchased		No		100	f	38.9125	1.5	7			

M6061T6B0 500X06 000
6061-T6 Bar .500 x 6.00

6.796'

SS 14-04-21

Location

Loc Qty

Loc Code

MAT005

38.9125

122521

7.747

m126647

15.2905

m128437

15.875

6.796'

DART AEROSPACE LTD		Work Order:	116467
Description: Arm		Part Number:	D2802-1
Inspection Dwg: D2802 Rev: A		Page 1 of 1	

FIRST ARTICLE INSPECTION CHECKLIST

☒
First Article
☐
Prototype

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
0.500	+/-0.010	.504	✓		MH-04	Caliper
Ø0.191	+0.005/-0.001	.192	✓			
1.500	+/-0.010	1.500	✓			
0.100	+/-0.010	.102	✓			
9.358	+/-0.010	9.358	✓		Cre on	
Ø0.507	+0.000/-0.001	.506	✓		Pinsurge	-
2.033	+/-0.010	2.033	✓		MH-04	Caliper
1.000	+/-0.010	1.001	✓			
2.000	+/-0.010	2.000	✓			
1.347	+/-0.010	1.349	✓			
R0.75	+/-0.030	.75	✓		rad surge	-
R0.0300	+/-0.010	.03	✓		rad surge	-
R0.125	+/-0.010	.125	✓		rad surge	-
0.500	+/-0.010	.503	✓		MH-04	Caliper
0.125	+/-0.010	.129	✓			
Ø0.507 x 0.250	+0.000/-0.001 x +/-0.010	.5065 x .250	✓			
Ø0.375 x 100°	+/-0.010 x 0.5°	.375 x 100°	✓			
0.250	+/-0.010	.245	✓			
R0.032	+/-0.010	.032			rad surge	-

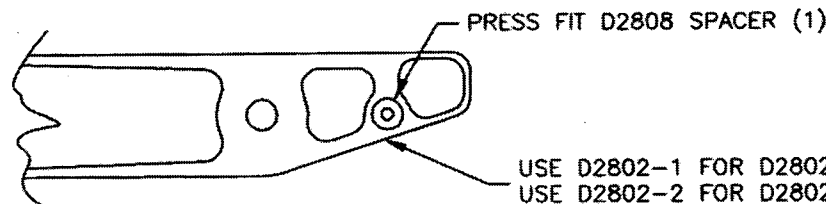
Measured by: MH	Audited by: DAS 44 9-89	Prototype Approval:	N/A
Date: 14/04/22	Date: 14/04/22	Date:	N/A

Rev	Date	Change	Revised by	Approved
A	06.08.29	New Issue	KJ/JLM	

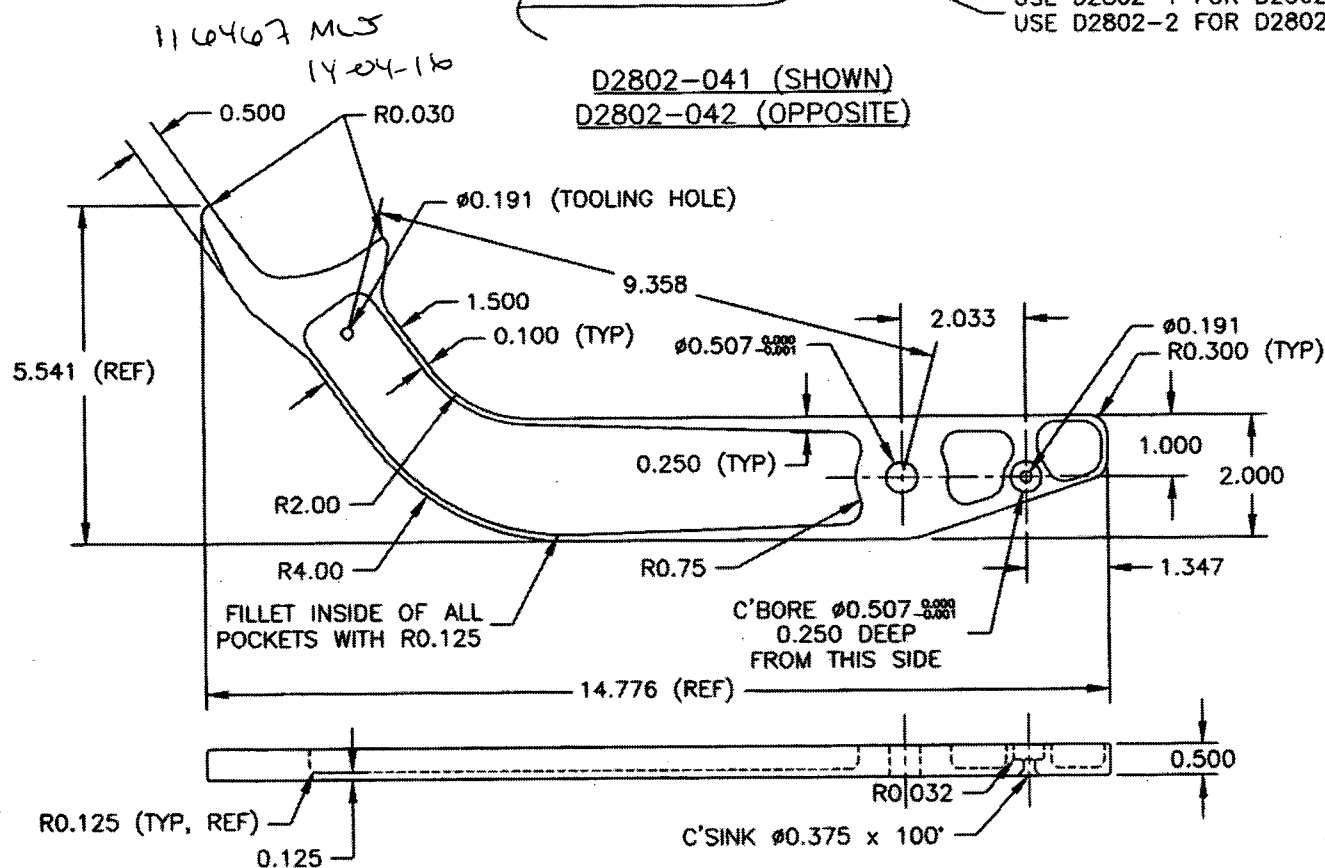
DART



DESIGN	DRAWN BY	DART AEROSPACE LTD
CHECKED <i>CP</i>	APPROVED <i>CP</i>	HAWKESBURY, ONTARIO, CANADA
DATE 00.11.03	TITLE ARM	DRAWING NO. D2802
A	00.11.03	NEW ISSUE
		REV. A
		SHEET 1 OF 1
		SCALE 1:3



D2802-041 (SHOWN)
D2802-042 (OPPOSITE)



D2802-1 (SHOWN)
D2802-2 (OPPOSITE)

MACHINE PER DRAWING FILE "D2802-A1.DWG"
MATERIAL: 6061-T6 (QQ-A-200/8) OR (QQ-A-250/11) 0.500 THICK (REF)
DEBURR TO LEAVE R0.030 - 0.063 ON ALL EDGES
TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

RELEASED
00-11-13

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